



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G11331-3G-01-PO
Job Sheet 187077



Part No: RBW6305G11331-3G-01-PO **Job Qty:** 1 ea

Part Name: Wrench Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 11/27/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6305G11331-3G Rev.C IPP Rev. A 18.11.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	Purchasing	1 pcs	11/27/18	11/27/18	0.00	0.00	Purchasing		NOV 27 2018
110	Packaging	1 pcs	11/27/18	11/27/18	0.00	0.00	Packaging2		NOV 27 2018
120	QC	1 pcs	11/27/18	11/27/18	0.00	0.00	QC6		38
130	Small Fab	1 pcs	11/27/18	11/27/18	0.00	0.10	Small Fab-2		MLC 9-89
140	QC	1 pcs	11/27/18	11/27/18	0.00	0.00	QC5		13-11-27
150	Packaging	1 pcs	11/27/18	11/27/18	0.00	0.00	Packaging3		MLC
160	QC21-SA	1 Ea	11/27/18	11/27/18	0.00	0.00	QC21		NOV 27 2018

Part Op 100 - Issue P/O: 041697 MANUFACTURE RBW6305G11331-3G-01 AS PER DWG Supplier: ARROW TECH
Descriptions: MACHINE WORKS -Certificate of conformity is required
130 - Re-identify as required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G11331-3G-01P	Wrench Weldment	1 (1 ea)	100-Purchasing	5131970
RBW6305G11331-3G-13		1		5073611

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6305G11331-3G-01P	1	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 11/27/18 12:42 PM dart.Lussier.Patrick

Container No: S131977



Part: RBW6305G11331-3G-01

Job No: 187077

Serial No/Batch: S131977

Revision: C

Inspector:

Exp Date:

Instructions: <https://www.plexonline.com/1cbd4...> 1/1

NOV 23 1918
NOV 23 1918

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1918

NOV 23 1918

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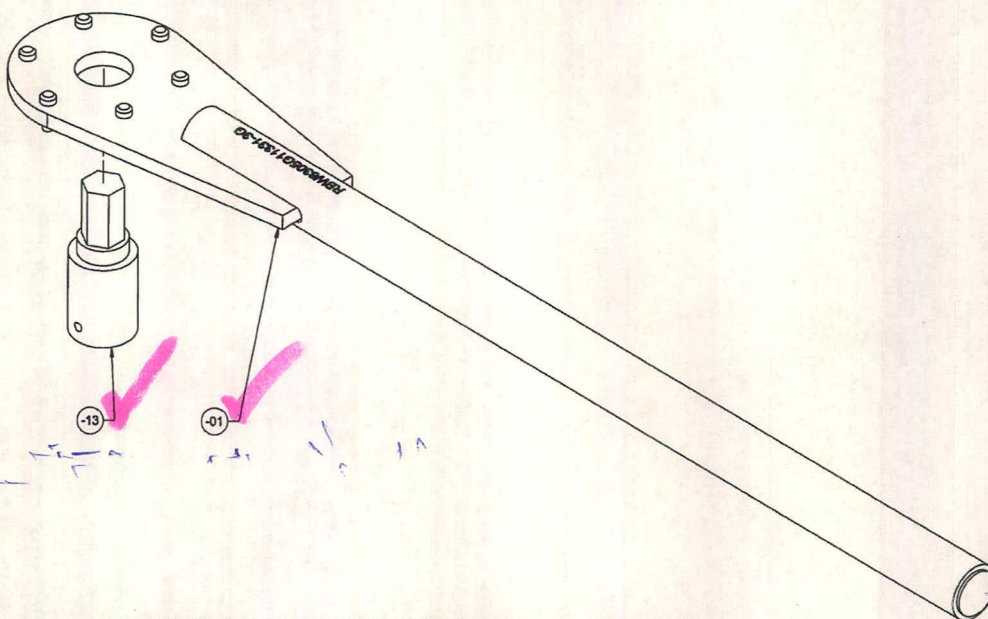
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NOV 23 1918

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ITEM #	QTY	PART #	PART TITLE
-01	1	RBW6305G11331-3G-01	WRENCH WELDMENT
-13	1	RBW6305G11331-3G-13	SOCKET



RBW6305G11331-3G MAIN GEAR BOX INPUT PINION RING NUT WRENCH

NOTES:

1) MATERIAL: N/A
2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$

X.XX = $\pm 0.01"$ / $\pm 0.5"$

X.XXX = $\pm 0.005"$ / $\pm 0.1"$

X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

C	ITEM -13 SOCKET ADDED, TEMPLATE UPDATED	18-538	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
DRAWN	VM 04/17/2018		
CHECKED	VM 04/17/2018		
MFG. APPR.	DP 04/18/2018		
APPROVED	ML 04/24/2018		
DATE	4/24/2018		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

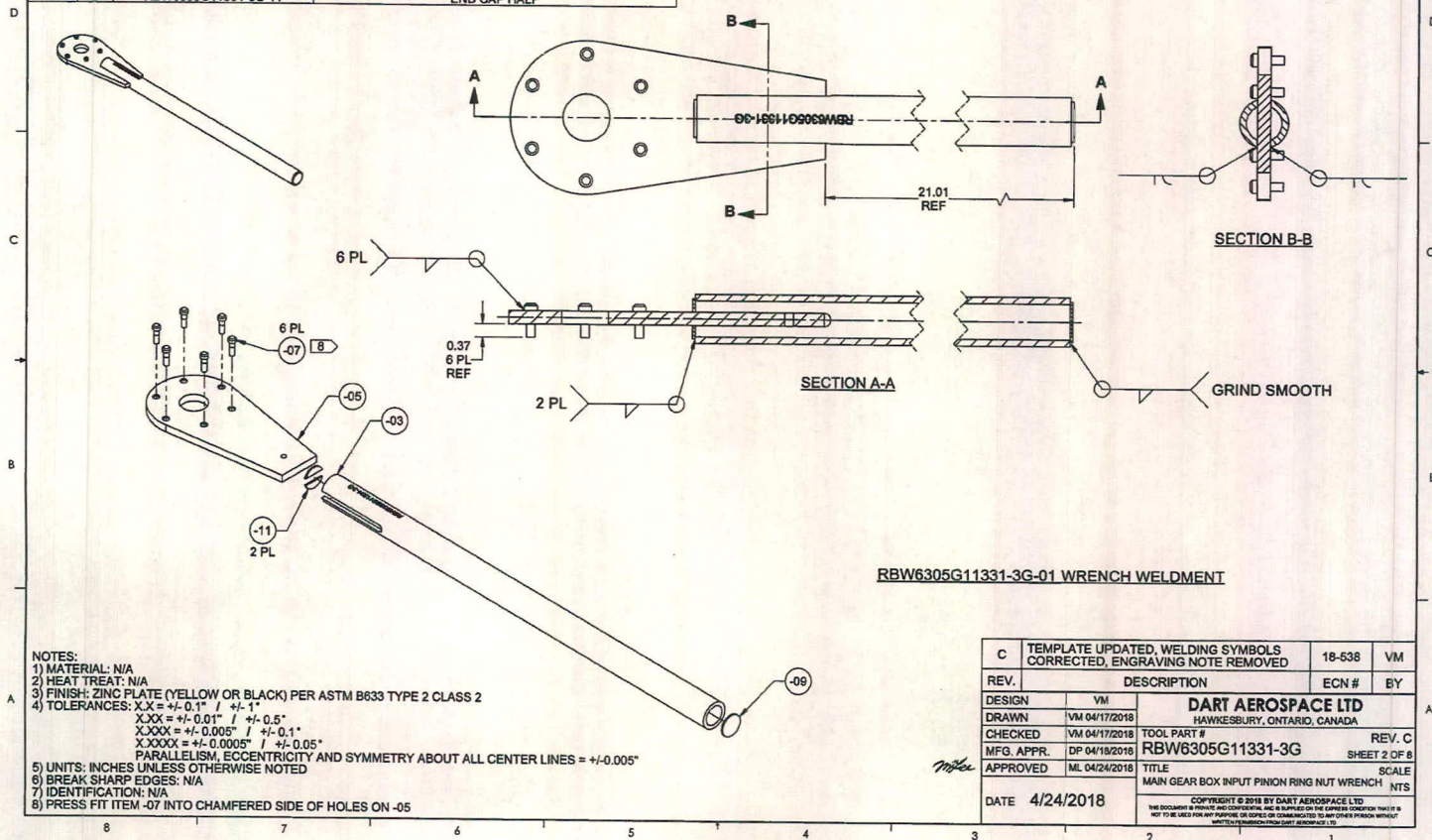
TOOL PART #
RBW6305G11331-3G

TITLE
MAIN GEAR BOX INPUT PINION RING NUT WRENCH

SCALE
ITS

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ITEM #	QTY	PART #	PART TITLE
-03	1	RBW6305G11331-3G-03	HANDLE
-05	1	RBW6305G11331-3G-05	PLATE
-07	6	RBW6305G11331-3G-07	LUGS
-09	1	RBW6305G11331-3G-09	END CAP
-11	2	RBW6305G11331-3G-11	END CAP HALF



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) PRESS FIT ITEM -07 INTO CHAMFERED SIDE OF HOLES ON -05

C	TEMPLATE UPDATED, WELDING SYMBOLS CORRECTED, ENGRAVING NOTE REMOVED	18-538	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
DRAWN	VM 04/17/2018		
CHECKED	VM 04/17/2018		
MFG. APPR.	DP 04/18/2018		
APPROVED	ML 04/24/2018		
DATE	4/24/2018		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

TOOL PART #

RBW6305G11331-3G

MAIN GEAR BOX INPUT PINION RING NUT WRENCH

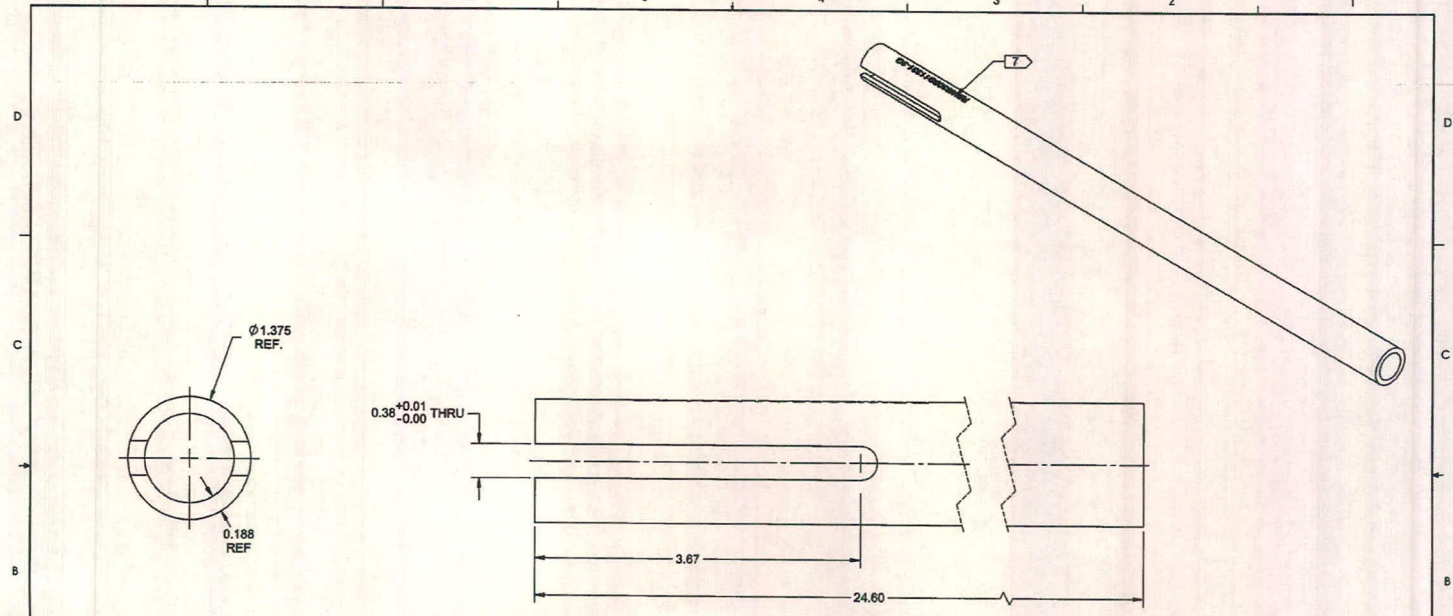
SCALE

NTS

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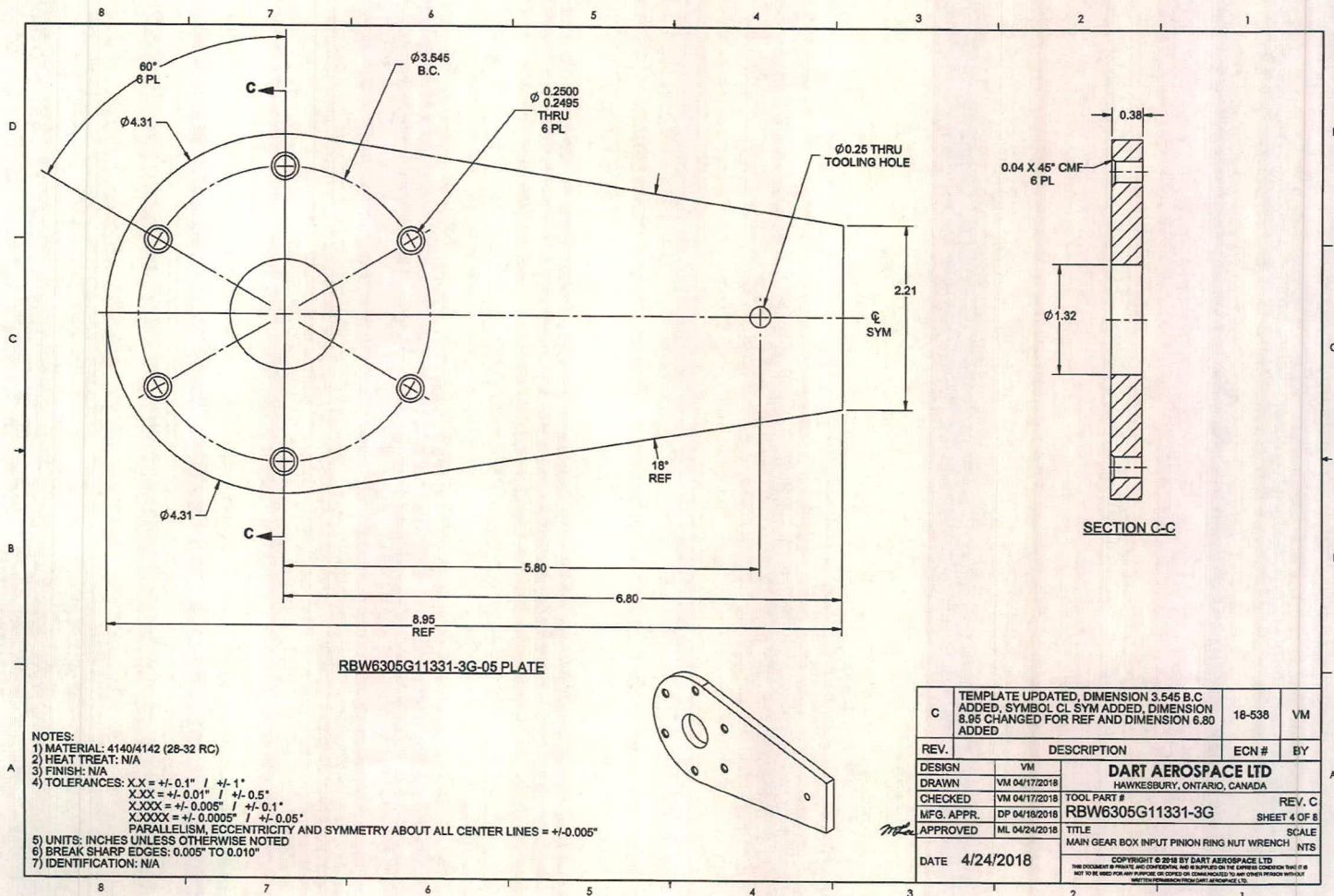


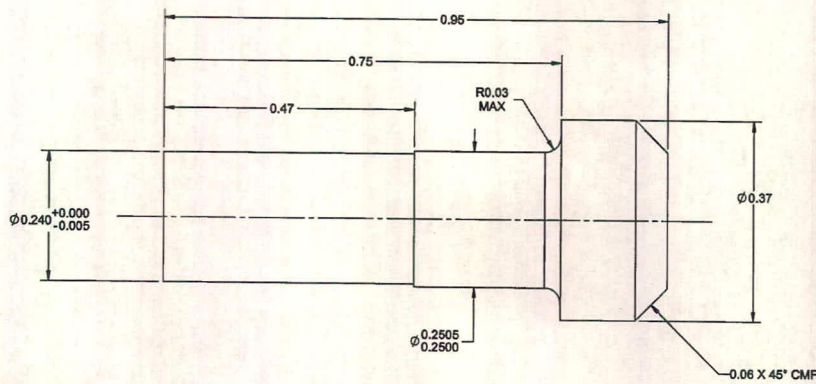
RBW6305G11331-3G-03 HANDLE

- NOTES:
- 1) MATERIAL: McMaster#7767T65 OR EQUIV
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
 X.XX = +/- 0.01" / +/- 0.5"
 X.XXX = +/- 0.005" / +/- 0.1"
 X.XXXX = +/- 0.0005" / +/- 0.05"
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN

C	MATERIAL CHANGED FOR MM#6, TEMPLATE UPDATED, ENGRAVING NOTE 7 ADDED, MADE IN USA & S/N REMOVED FROM ENGRAVING, DIMENSION .375 CHANGED FOR .38 +/-0/-0			18-538	VM
	REV.	DESCRIPTION		ECN #	BY
DESIGN	VM		DART AEROSPACE LTD		
DRAWN	VM 04/17/2018		HAWKESBURY, ONTARIO, CANADA		
CHECKED	VM 04/17/2018		TOOL PART #	REV. C	
MFG. APPR.	DP 04/18/2018		RBW6305G11331-3G		SHEET 3 OF 8
APPROVED	ML 04/24/2018		TITLE	SCALE	
			MAIN GEAR BOX INPUT PINION RING NUT WRENCH		
DATE 4/24/2018			NTS		
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8 7 6 5 4 3 2 1





RBW6305G11331-3G-07 LUGS

NOTES:

1) MATERIAL: 4140/4142 (28-32 RC)

2) HEAT TREAT: 30-35 Rc

3) FINISH: N/A

4) TOLERANCES: XX = $\pm 0.1^\circ$ / $\pm 1^\circ$

XXX = $\pm 0.01^\circ$ / $\pm 0.5^\circ$

XXXX = $\pm 0.005^\circ$ / $\pm 0.1^\circ$

XXXXX = $\pm 0.0005^\circ$ / $\pm 0.05^\circ$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005^\circ$

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

C	TEMPLATE UPDATED, DIMENSION .242 $\pm 0.01/-0$ CHANGED FOR .2500/.2505, DIMENSION .240 ± 0.002 CHANGED FOR .240 $\pm 0/-0.005$	18-538	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
DRAWN	VM 04/17/2018		
CHECKED	VM 04/17/2018		
MFG. APPR.	DP 04/18/2018		
APPROVED	ML 04/24/2018		
DATE	4/24/2018		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

TOOL PART #

RBW6305G11331-3G

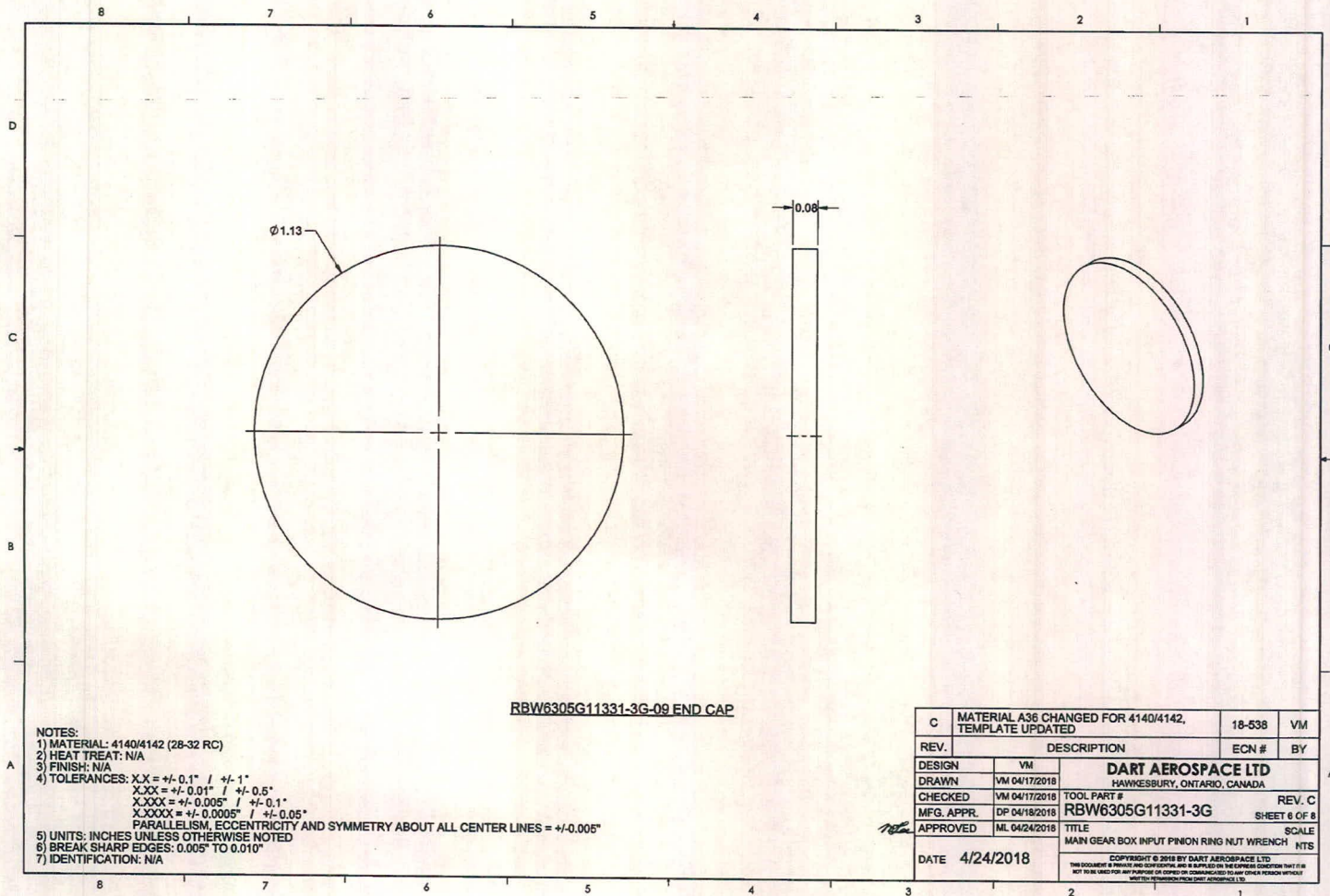
MAIN GEAR BOX INPUT PINION RING NUT WRENCH

SCALE

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SHEET 5 OF 8

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RBW6305G11331-3G-09 END CAP

NOTES:

1) MATERIAL: 4140/4142 (28-32 RC)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: XX = ± 0.1 " / ± 1 "

XXX = ± 0.01 " / ± 0.5 "

XXXX = ± 0.005 " / ± 0.1 "

XXXXX = ± 0.0005 " / ± 0.05 "

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "

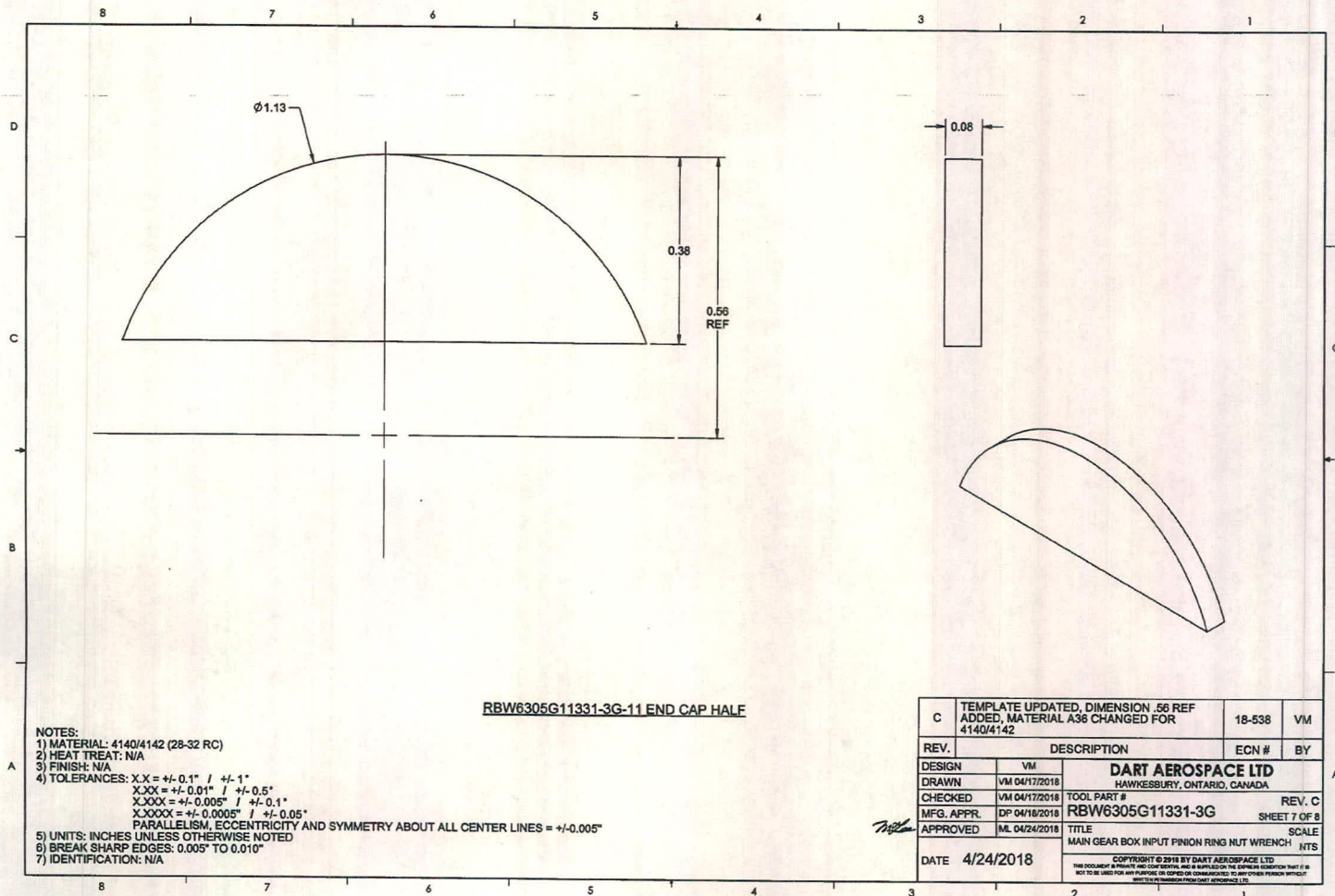
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

C	MATERIAL A36 CHANGED FOR 4140/4142, TEMPLATE UPDATED		18-538	VM
REV.	DESCRIPTION		ECN #	BY
DESIGN	VM	DART AEROSPACE LTD		
DRAWN	VM 04/17/2018	HAWKESBURY, ONTARIO, CANADA		
CHECKED	VM 04/17/2018	TOOL PART #	REV. C	
MFG. APPR.	DP 04/18/2018	RBW6305G11331-3G	SHEET 8 OF 8	
APPROVED	ML 04/24/2018	TITLE	SCALE	NTS
DATE	4/24/2018	MAIN GEAR BOX INPUT PINION RING NUT WRENCH		

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RBW6305G11331-3G-11 END CAP HALF

NOTES:

1) MATERIAL: 4140/4142 (28-32 RC)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$

XXX = $\pm 0.01"$ / $\pm 0.5"$

XXXX = $\pm 0.005"$ / $\pm 0.1"$

XXXXX = $\pm 0.0005"$ / $\pm 0.05"$

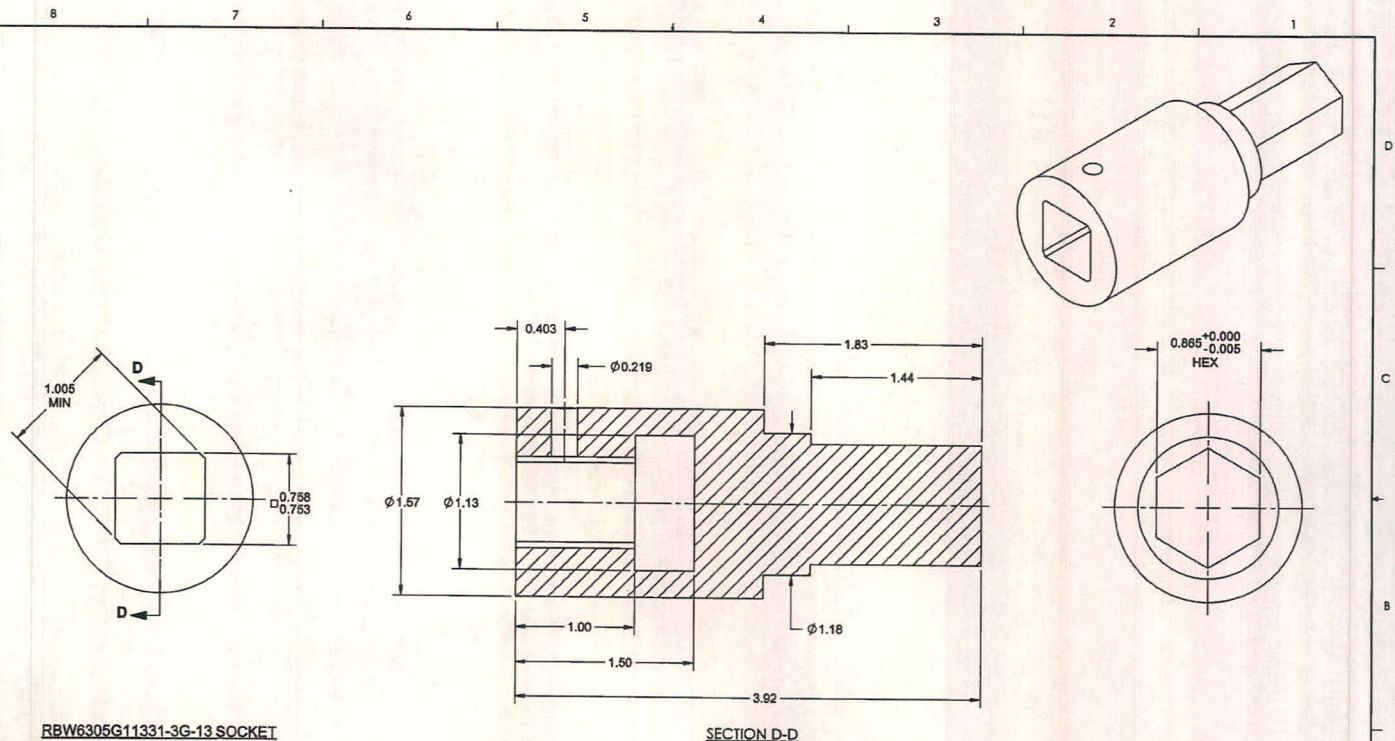
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

C	TEMPLATE UPDATED, DIMENSION .56 REF ADDED, MATERIAL A36 CHANGED FOR 4140/4142		18-538	VM
REV.	DESCRIPTION		ECN #	BY
DESIGN	VM	DART AEROSPACE LTD		
DRAWN	VM 04/17/2018	HAWKESBURY, ONTARIO, CANADA		
CHECKED	VM 04/17/2018	TOOL PART #		REV. C
MFG. APPR.	DP 04/18/2018	RBW6305G11331-3G		SHEET 7 OF 8
APPROVED	ML 04/24/2018	TITLE		SCALE
DATE 4/24/2018		MAIN GEAR BOX INPUT PINION RING NUT WRENCH		
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NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = ± 0.1 / ± 1
X.XX = ± 0.01 / ± 0.5
X.XXX = ± 0.005 / ± 0.1
X.XXXX = ± 0.0005 / ± 0.05
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

C	MISSING PART ADDED	18-538	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
DRAWN	VM 04/17/2018		
CHECKED	VM 04/17/2018		
MFG. APPR.	DP 04/18/2018		
APPROVED	ML 04/24/2018		
DATE	4/24/2018		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
TOOL PART #
RBW6305G11331-3G
TITLE
MAIN GEAR BOX INPUT PINION RING NUT WRENCH
REV. C
SHEET 8 OF 8
SCALE
NTS

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041697**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041697
PO Date: 11/12/18
Due Date: 11/27/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187077	RBW6305G11331-3G-01P			Wrench Weldment	Firmed -		11/27/18 NOV 27 2018	1 Ea	0 Ea	1 Ea	\$2,139.00/Ea	\$2,139.00
Grand Total:													\$2,139.00

AS
38
-89

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/27/18 12:53 PM dart.Lussier.Patrick

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Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

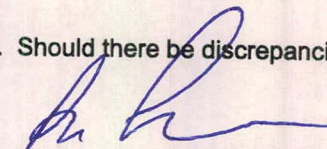
Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24293
Shipment Date: 27-Nov-2018
Ship Via: Pick up at METEC

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041697 ✓

Quantity								
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Job Number
1	0	1 ✓	0	0	EA	DART-RBW6305G11331-3G-01P Wrench Weldment	C	DAS 38 9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.



Received In Good Order By

0/0
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29



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev#	P.O. Number
1	RBW6305G11331-3G-01P	Wrench Weldment	C	PO041697

No deviations for this part

Material supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

DAS
38
9-89

METEC Metal Technology Inc.


Christian Walz

Vankleek Hill, November 27, 2018

540
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2